

Work Order ID 72386-1

Monday, July 25, 2011 9:17:18 AM

Page 1

Item ID: D4360-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 7/25/2011 Start Qty: 8.00

Required Date: 8/2/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

Date: 11-07-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4360

B

100

0.00



Waterjet

FLOW CNC Waterjet

304 .063

Memo

0.00

1-Cut as per Dwg (D4360-1)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start

Stop



1311-8-9

14

1311-8-9

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Item ID: D4360-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate Assembly

Start Date: 7/25/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

Sullosly

(714)

130



Large Fab

Large Fab

Memo

1- Weld cups as per dwg
A/R S.S. ROD BATCH: *MI17659 / MI14509*

2- Apply hardfacing on wearplate as indicated on dwg
A/R HARDCOAT 2059B BATCH: *MI19061*

0.00

0.00

0.00

Memo

QC5- Inspect part completeness to step on W/O

Sullosly

X4 11-10-27 JBL

(X4)

140



QC

Quality Control

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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

PC 11.10.27

4

0

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: ST 500 0.00

Packaging

Memo

0.00

Packaging

fx SP 11-10-31

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/10/31
mf
11-10-31

Picklist Print

Monday, July 25, 2011 9:17:44 AM

Page 1

Work Order ID: 72386



Parent Item: D4360-041



Parent Item Name: Wearplate Assembly



Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	219.4000	0.97867	8.241432	14		
										(B)1-E-9			
304/316 Sheet .063													

	Location	Loc Qty	Loc Code
	MAT020	19.4	
	117275	1.7	
	117653	17.7	
	MAT021	200	
	118217	200	
D4379-1			
	Manufactured	No	
		130	Each
		0.0000	12
			96

Wearplate Cup

W/A

B 70685 - X ~~1~~ 1


B 72388 - X ~~1~~ 47

1/BL 11-10-26

(14)

118217

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue P/O D4360-041	KJ	

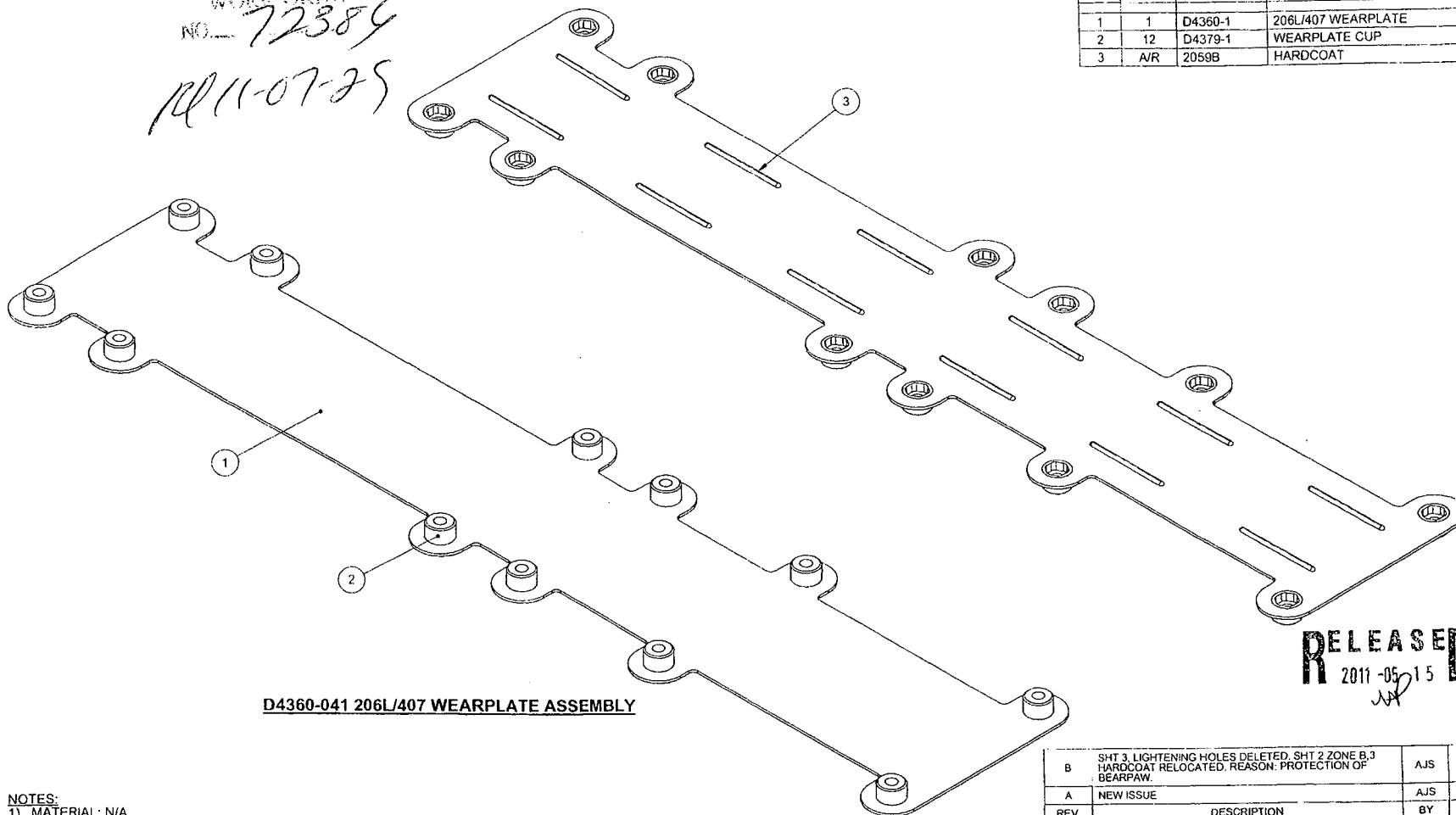
UNCONTROLLED COPY
 (SUBJECT TO MANAGEMENT)

WITHOUT NOTICE
 WORK ORDER

NO. 72384

11-07-25

ITEM	QTY	P/N	DESCRIPTION
	X	D4360-041	206L/407 WEARPLATE ASSEMBLY
1	1	D4360-1	206L/407 WEARPLATE
2	12	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



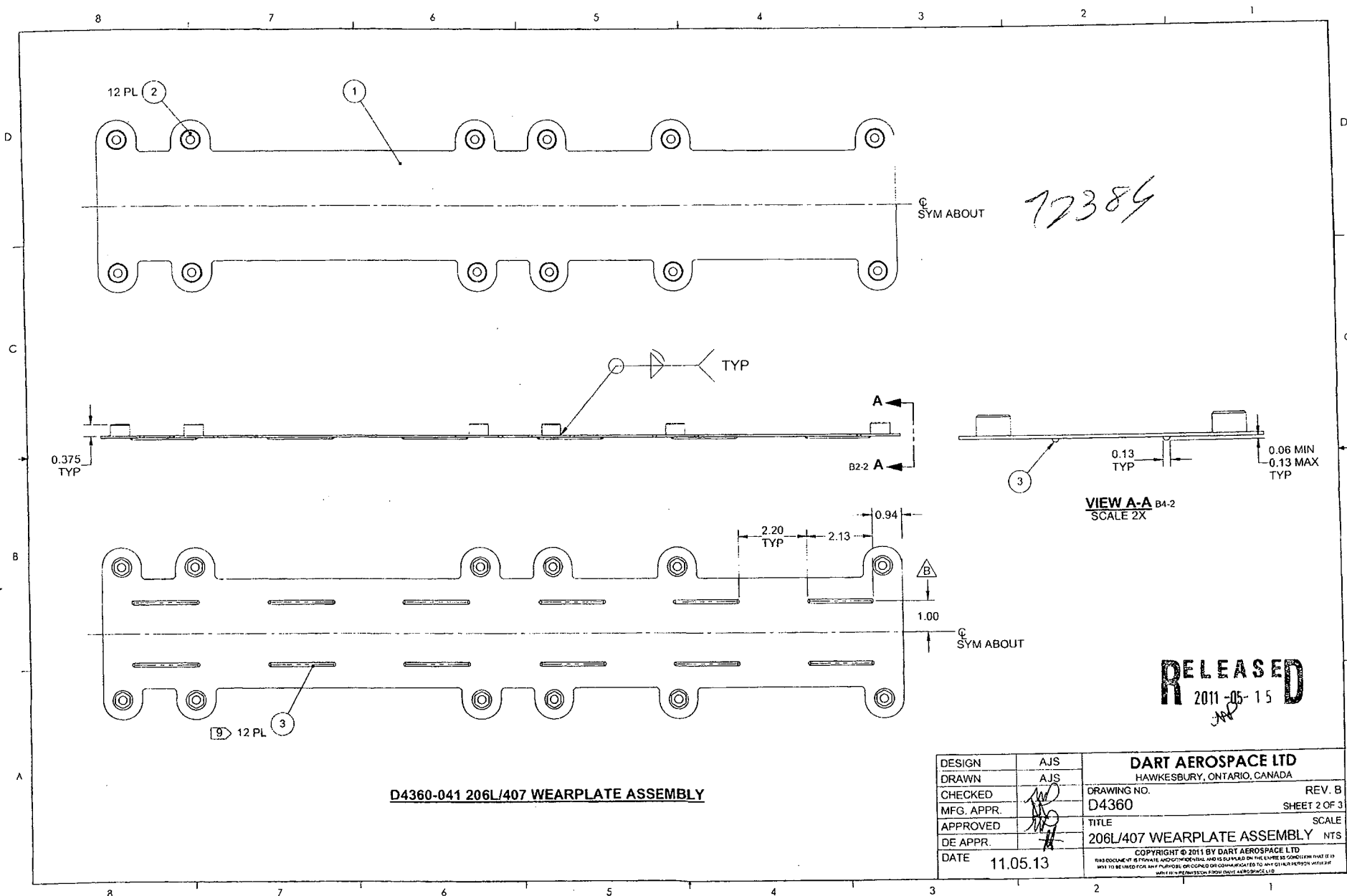
D4360-041 206L/407 WEARPLATE ASSEMBLY

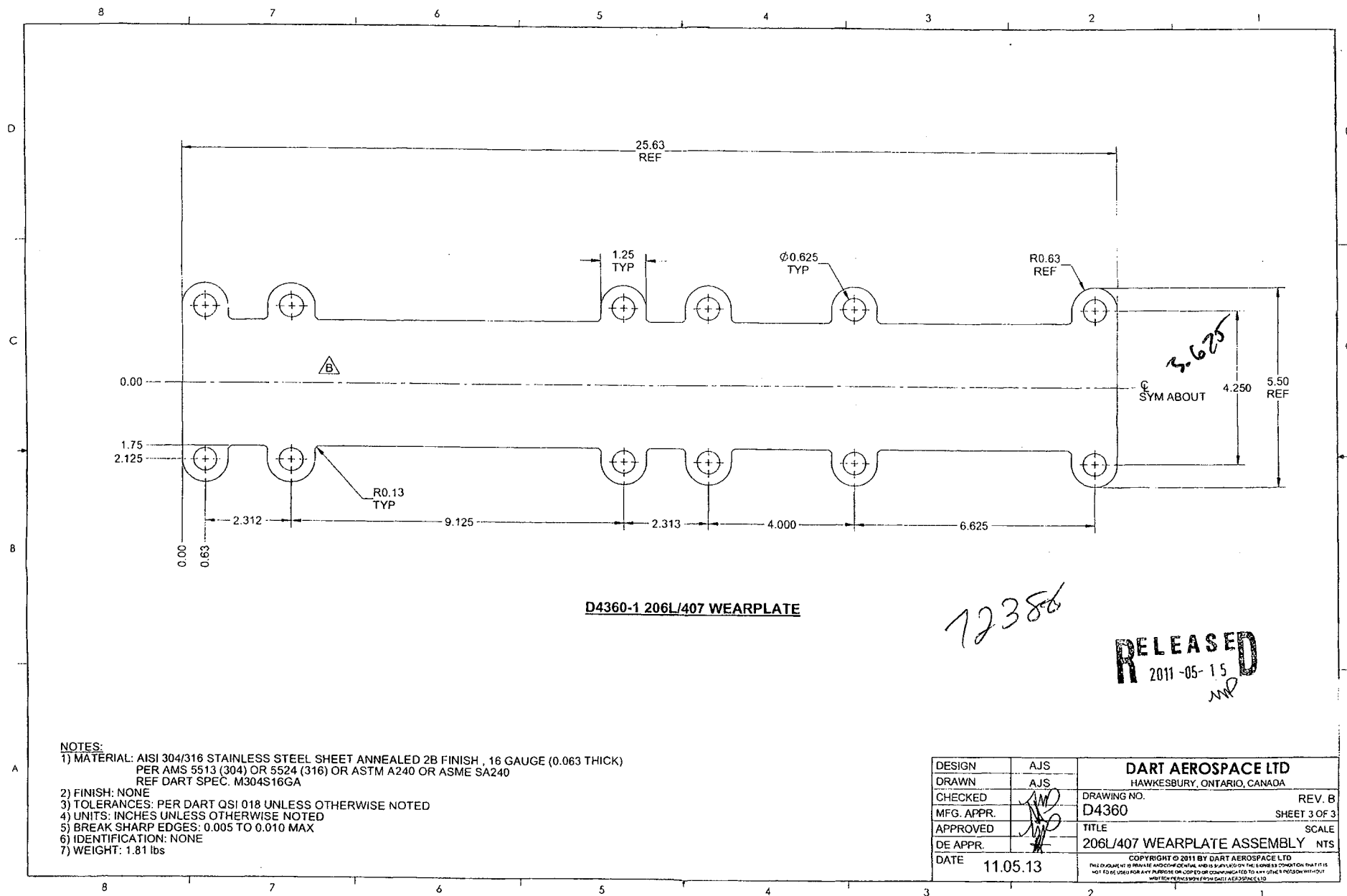
RELEASED
 2011-05-15

NOTES:





- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4360-041" AND B/N "BXXXXX"
 PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.10 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B		SHT 3, LIGHTENING HOLES DELETED. SHT 2 ZONE B,3 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW.	AJS	11.05.13
A		NEW ISSUE	AJS	11.03.22
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D4360		SHEET 1 OF 3
APPROVED		TITLE	SCALE	
DE APPR.		206L/407 WEARPLATE ASSEMBLY	NTS	
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D4360-1 206L/407 WEARPLATE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4360	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		206L/407 WEARPLATE ASSEMBLY	NTS
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